



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel: (613) 632-5200

D3065-5
Job Sheet 173418



Part No: D3065-5

Job Qty: 100 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/9/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Waterjet		SC 8/03/03
100	Waterjet	100 pcs	3/8/18	3/8/18	0.02	9.22	Waterjet1		SC 18/03/03
120	QC	100 pcs	3/8/18	3/8/18	0.00	0.00	QC8		SC 38
130	HandFinish	100 pcs	3/9/18	3/9/18	0.00	2.26	HandFinish1		SA 18/03/14
140	QC	100 pcs	3/9/18	3/9/18	0.00	0.00	QC7-1	GA	SA 15 2018
150	Packaging	100 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3		SA 9-89
160	QC21-SA	100 Ea	3/9/18	3/9/18	0.00	0.00	QC21		GA 1/16

Part Op 100 - 1-Cut as per Dwg
Descriptions: 150 - LOCATION : GA

DAB
21
9-89

MAR 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	82.5000 sf (.825 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	83	177	0

8023289 - (30) sf

8013853 - (24) sf

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wor _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS ater Jet ☐ 3. Coord. ☐ Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐ Part: D3065-5 Job No: 173418 Serial No/Batch: S049402 Container No: S049402 DART Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON N6A 1K7 CANADA TEL: 905 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 03/09/18 MRB (CS1042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																				
Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">☐ Environment</td> <td style="width: 15%;">☐ No Re-verification</td> <td style="width: 15%;">☐ Pressure/Forced</td> <td style="width: 15%;">☐ Temperature/Cure</td> <td style="width: 15%;">☐ Power Loss/Surge</td> <td style="width: 15%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Design</td> <td>☐ Operator</td> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Doc/Data</td> <td>☐ Offset/Setup</td> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Equip/Tooling</td> <td>☐ Supplier</td> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Handling/Pre</td> <td>☐ Training</td> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Material</td> <td>☐ Use for Testing</td> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Internal Transport</td> <td>☐ Poor Information</td> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Tribal Knowledge</td> <td>☐ Rushing</td> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ LOA</td> <td>☐ Product Improvement</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Substation</td> <td>☐ Process Improvement</td> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> <tr> <td>☐ Past Expiry Date</td> <td>☐ Manufacturing Process</td> <td colspan="4" rowspan="2" style="vertical-align: top;"> OTHER : _____ </td> </tr> <tr> <td>☐ Misidentified</td> <td>☐ Past Due</td> </tr> </table>			☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____				☐ Misidentified	☐ Past Due
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches $\pm$ 0.010	16.468 16.448	16,459	
2	Step Log	15.750inches $\pm$ 0.005	15.755 15.745	15,751	
3	Step Log	2.250inches $\pm$ 0.005	2.255 2.245	2,250	
4	Step Log	3.460inches $\pm$ 0.005	3.465 3.455	3,460	
5	Step Log	0.865inches $\pm$ 0.005	0.870 0.860	0,864	
6	Step Log	6.020inches $\pm$ 0.005	6.025 6.015	6,022	
7	Step Log	1.205inches $\pm$ 0.005	1.210 1.200	1,206	
8	Step Log	3.484inches $\pm$ 0.005	3.489 3.479	3,485	
9	Step Log	0.871inches $\pm$ 0.005	0.876 0.866	0,870	
10	Step Log	8.325inches $\pm$ 0.010	8.335 8.315	8,325	
11	Step Log	0.551inches $\pm$ 0.010	0.561 0.541	0,550	
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213	0,214	
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128	0,128 0,129	

Plex 3/1/18 1:55 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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